

Date: Wednesday, 04/10/2006 2:21:56 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GASKET	
Job Number	: 28839		Part Number	: D32555	
Estimate Number	: 10433		Drawing Number	: D3255 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 04/10/2006	S.O. No.	Type	: PURCHASED PARTS	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 20/10/2006	
Previous Run	: 28839		Qty:	6 Um: Each	
Written By					
Checked & Approved By					
Comment	: Est A 04.05.12 New issue KJ/RF Est Rev:B Now On Waterjet 06-08-14 JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D3255	Gasket
Comment: Qty.: 1.6182 Each(s)/Unit Total : 9.7089 Each(s) Gasket use D3255 .063" thick silicone coated fiberglass Batch: B28853		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per.Dwg D3255 Dwg Rev: B Prog Rev: B		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location ST87		

Date: Wednesday, 04/10/2006 2:21:56 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 28839

Part Number: D32555

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

4/10/06/22

Job Completion



4/10/06/22

Date: Tuesday, 10/3/2006 2:51:29 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: GASKET		
Job Number	: 28839			Part Number	: D32555		
Estimate Number	: 10433			Drawing Number	: D3255 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/3/2006 S.O. No. :			Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : PURCHASED PARTS			Due Date	: 10/25/2006 Qty: 6 Um: Each		
Previous Run	: 28136						
Written By	: <u>10/06 10 03</u>						
Checked & Approved By							
Comment	: Est A 04.05.12 New issue KJ/RF Est Rev:B Now On Waterjet 06-08-14 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D3255	Gasket 
<b>Comment:</b> Qty.: 1.6182 Each(s)/Unit Total : 9.7089 Each(s) Gasket use D3255 .063" thick silicone coated fiberglass Batch: _____		
2.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
3.0	QC8	SECOND CHECK 
<b>Comment:</b> SECOND CHECK		
4.0	PACKAGING 1	PACKAGING RESOURCE #1 
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location _____		
5.0	QC21	FINAL INSPECTION/W/O RELEASE 
<b>Comment:</b> FINAL INSPECTION/W/O RELEASE		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

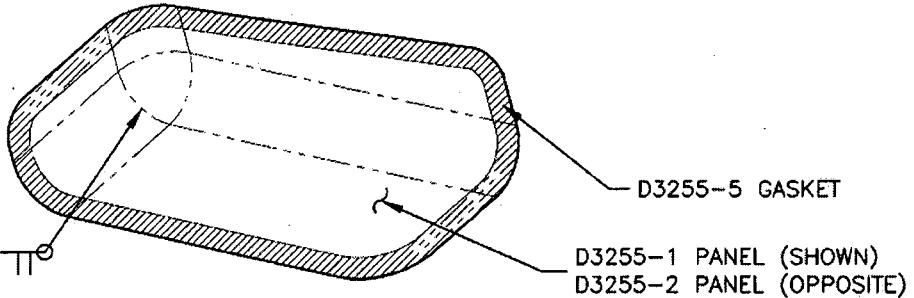
NOTE: Date & initial all entries

**DART**

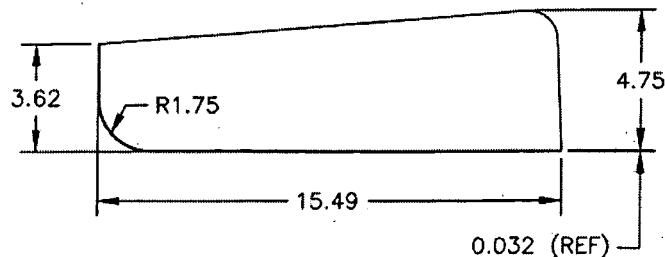
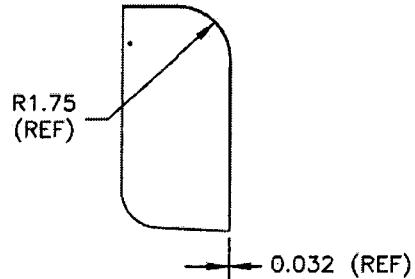
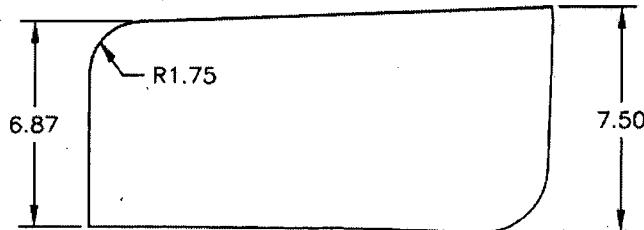
DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>MM</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

**RELEASED**  
05.01.18 *sf*

WELD D3255-3



**D3255-041 ACCESS PANEL (SHOWN)  
D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL  
D3255-2 OPPOSITE**

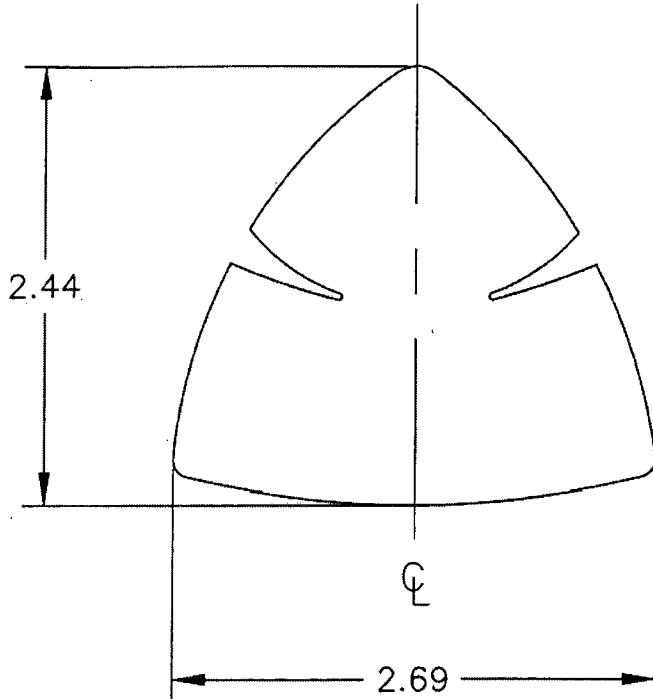
**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *28839*

**DART**

DESIGN DF	DRAWN BY DF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 91	APPROVED <del>HF</del>	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE	SCALE 1:1

**RELEASED**  
05-01-08 ~~HF~~

D3255-3 CAP  
FORM TO FIT D3155-1/-2

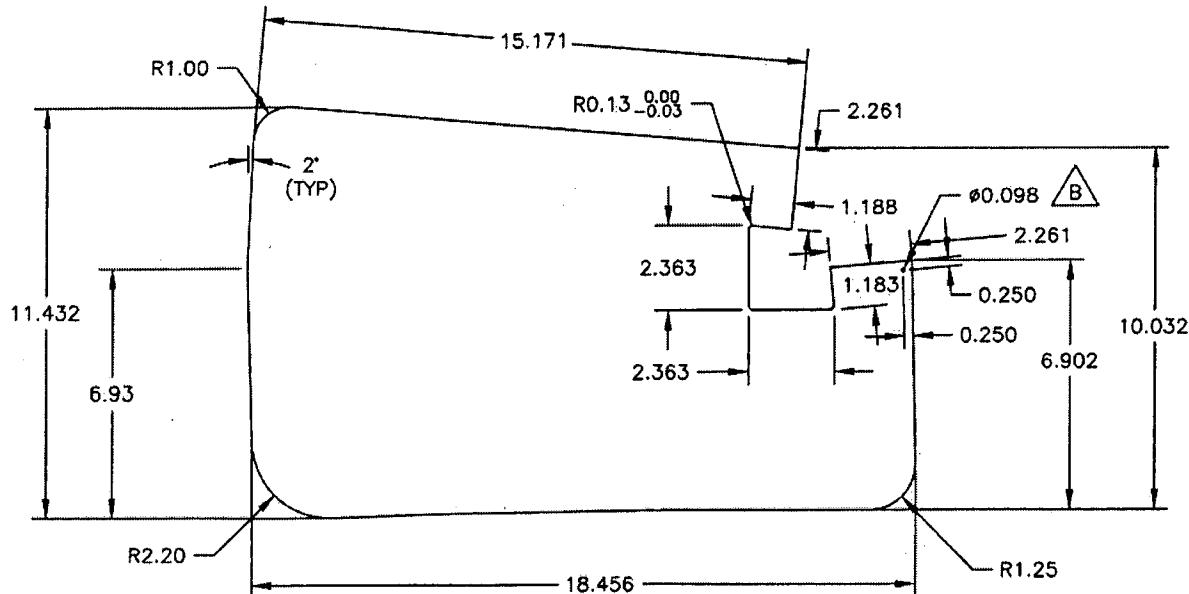
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) MAKE PER DRAWING "D3255-B2.DWG"

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 28839

**DART**

DESIGN <i>PF</i>	DRAWN BY <i>PF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>GP</i>	APPROVED <i>HF</i>	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

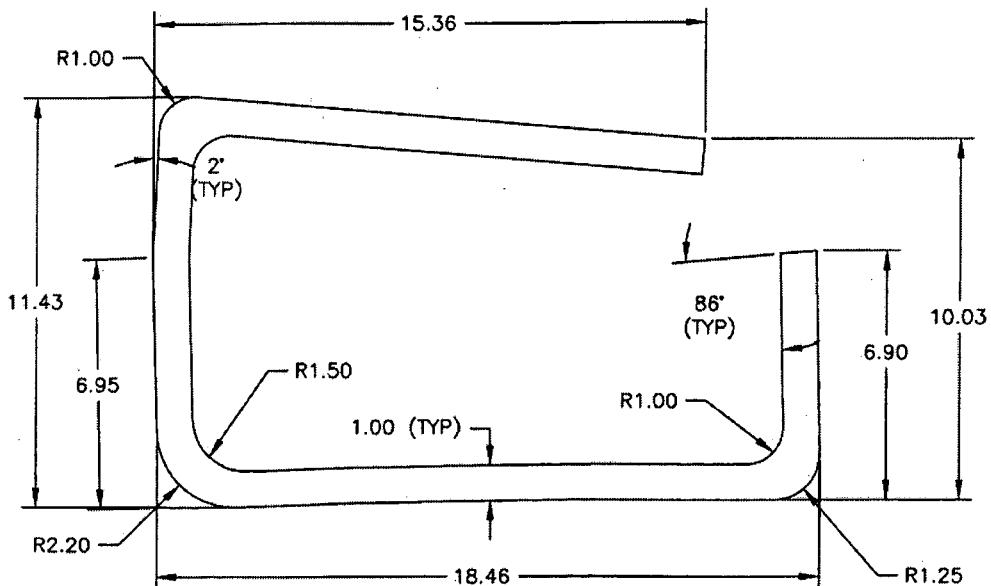
**RELEASED**  
05-01-18 *HF***D3255-1/-2 FLAT PATTERN****D3255-1/-2 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *28839*

**DART**

DESIGN <i>TP</i>	DRAWN BY <i>TP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>TP</i>	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

**RELEASED**  
05.01.08 *TP***D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28839

DART AEROSPACE LTD

Work Order: 28839

Description: GASKET

Part Number: D32555

Inspection Dwg: D2155 Rev: B

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 1.00	+/- 0.030	0.980	✓		Vern	
B 18.46	+/- 0.030	18.440	✓		M-T	
C 11.43	+/- 0.030	11.44	✓		M-T	
D 15.36	+/- 0.030	15.375	✓		M-T	
E 6.90	+/- 0.030	6.91	✓		Vern	
F Ø 0.63	+/- 0.010	0.666	✓		Vern	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD

Audited by: En

Prototype Approval: N/A

Date: 07/06/19

Date: 07/06/20

Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	